

ABSTRACT

5 A process for productive an easy-open can lid made
of a resin laminated metal sheet comprising laminating a
metal sheet or surface-treated metal sheet on one or both
surfaces thereof with a crystalline saturated polyester
resin film having a thickness of 10 to 100 μm , an
elongation of at least 150%, a degree of crystallinity of
not more than 10%, and a heat of fusion of crystalline of
10 not less than 10 joules/g, to form a laminated metal
sheet for an easy-open can, forming by a composite cold-
forming method a tear-along grooves of a residual
thickness of not more than 1/2 of the thickness of the
material using top and bottom dies of a die radius of 0.1
15 to 1.0 mm, then heat treating the crystalline saturated
polyester resin layer at the portion surrounding the
tear-along groove at a temperature of at least the
crystallization starting temperature and less than the
melting point thereof and, also, an easy-open can lid
20 obtained by the same and a resin laminated metal sheet
used for the same.